Wednesday, 29/10/2008 10:10:32 AM Üser: Melanie Fauteux Customer : CU-DAR001 Dart Helicopters Services Job Number -: 43060 Estimate Number : 13436 P.O. Number This Issue : 29/10/2008 Prsht Rev. : NC : 11 First Issue : 41366 Previous Run Written By Checked & Approved By Comment **Additional Product** Job Number: Seq. #:

Process Sheet

Drawing Name

: AFT ADJUSTABLE BLADE SUPPORT ASSY

Part Number

: PB674300113

Drawing Number

: B6743001 P.8 : N/A

Project Number **Drawing Revision**

: B1

Material

: 05/11/2008 **Due Date**

Qty:

Each 1 Um:

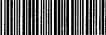
08-10-29

S.O. No. :

Type

08-06-26 new issue DD verified by:ec : Est Rev:A

: LARGE FAB ASSY



Description:

PB6743001255 1.0



Inner Tube



Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

108-11-19

2.0

PB6743001249

Inner Tube

Inner Tube Bushing



1.0000 Each(s)/Unit Total:

1.0000 Each(s)

Inner Tube Bushing batch: b

3.0

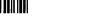
PB6743001253

Gusset



Comment: Qty.:

Comment: Qty.:





batch:

1.0000 Each(s)



4.0

PB6743001254

Gusset

Gusset





Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)



Gusset batch: 414 93

5.0

PB67430016

PB67-43001-67



Comment: Qty.: 1.0000 Each(s)/Unit Total: PB67-43001-67 batch: 41214.

1.0000 Each(s)

Mix

08-11-14

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Ca | itegory: | | NCR: Yes | No DQ | 4: | Date: | |
| Resolution: | | | Disposition: | | | QA: N/C Closed: Date: | | | | |
| NCR: | | | WORK OR | DER NON-CON | FORMAN | CE (NCF | ₹) | | | |
| DATE | STEP | Description of NC | Corrective Action Section | | | | | Verification | Approval | Approval |
| | 012. | Section A | Initial Chief Eng | Action Des Chief E | | Sign 8 Date | Secti | on C | Chief Eng | QC Inspector |
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Date: Wednesday, 29/10/2008 10:10:32 AM Melanie Fauteux User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY Job Number: 43060 **Part Number: PB674300113** Job Number: Seq. #: Description: **Machine Or Operation:** LARGE FAB 1 LARGE FABRICATION RESOURCE 1 6.0 Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg VISUAL WELDING INSPECTIO 7.0 QC9 Comment: VISUAL WELDING INSPECTION 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HELICAL INSERT 9.0 MS124780 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) **HELICAL INSERT** 10.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- install helicol insert as per dwg QC5 INSPECT WORK TO CURRENT STEP 11.0 Comment: INSPECT WORK TO CURRENT STEP 12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 13.0 M 102316 Comment: POWDER COATING 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Page 2

Form: rprocess

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| W/O: | · . [| | V | ORK ORDER CHANG | ES | | | | |
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| DATE STEP | | PROCEDURE CHANGE | | | | Da | te Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| DATE | CTED | Description of NC Section A | | ion B | \ | erification | Approval | Approval | |
| DATE | STEP | | Initial Chief Eng | Action Description Chief Eng | | n & ite | Section C | Chief Eng | QC Inspector |
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Wednesday, 29/10/2008 10:10:32 AM Date: User: Melanie Fauteux **Process Sheet** Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Job Number: 43060 Part Number: PB674300113 Job Number: Seq. #: **Machine Or Operation:** Description: START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 INSPECT POWDER COAT/CHEMICAL 14.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 15.0 PB674300169 90 Degree Cover Plate Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) 90 Degree Cover Plate batch:__ PB674300183 PB67-43001-83 16.0 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: PB67-43001-83 batch: MS27039110 17.0 Comment: Qty.: 8.0000 Each(s) 8.0000 Each(s)/Unit Total: Screw WASHER Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) **WASHER** SMALL & MEDIUM FAB RESOURCE 1 19.0 SMALL FAB Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg

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| W/O: | | | W | ORK ORDER CHANGE | S | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| NCR: | | | WORK ORI | DER NON-CONFORMA | NCE (NCF | ?) | | | | |
| DATE | STEP | Description of NC Section A | Corrective Action Section | | | Verifi | | Approval | Approval | |
| DAIL | SILF | | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | Secti | ion C | Chief Eng | QC Inspector | |
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Date:

Wednesday, 29/10/2008 10:10:32 AM

User:

Melanie Fauteux

Process Sheet

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services

Job Number: 43060

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



12 01





Comment: INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1



21.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishin

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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|---------|---------|-------------------|----------------------|------------------------------|-------------------------------------|--------------------------|-----------|--------------------------|
| W/O: | / | | W | ORK ORDER CHANG | ES | | | |
| DATE | STEP | PRO | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No |): | PAR #: | Fault Cat | egory: | _ NCR: Yes | No DQA: | Date: _ | |
| | R | esolution: | Dispositi | on: | _ QA: N/C Clo | osed: | Date: _ | |
| NCR: | | V | VORK ORE | DER NON-CONFORMA | NCE (NCR | 3) | | |
| | STEP | Description of NC | | Corrective Action Section | on B | Verification | Approval | Approval QC Inspector |
| DATE | | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | |
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